

Work Order ID 151935***151935***

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Friday, October 14, 2016 1:55:38 PM

Item ID: D2332-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lid Prop Assembly 6.69"

Stop

NS2

Start Date: 10/6/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 4.00

4

Customer:

Reference:

DAS

Approvals:

Process Plan:

21

9-89

Date: OCT 17 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

100

Small Fab

Memo

0.11

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

4

FF

DEC 06 2016

110

0.00

110

Brake NC

Memo

0.06

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

4

FF

DEC 06 2016

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Item ID: D2332-041

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N900040100

Setup Start

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Revision ID:

Stop

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Item Name: Lid Prop Assembly 6.69"

Start Date: 10/6/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Small Fab	Memo	0.09				4	FF		DEC 06 2016
Small Fab	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.01				4			16-12-06 DAS 9 9-89
Quality Control									
140		0.00							
140									
Large Fab	Memo	0.07				4			16-12-07 jm
Large Fab	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding*****								
	S.S Rod batch: 124992								

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Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lid Prop Assembly 6.69"
Start Date: 10/6/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				4			DAS 38 9-89 DEC 12 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>St307</u> Memo	0.00 0.01				4			DAS 6 9-89 DEC 13 2016
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-89 DEC 14 2016 MF 16-12-13

Picklist Print

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Work Order ID: 151935

151935

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A *AN4-4A* BOLT		Purchased	No			170	Each	103.0000	1	4			
										**	FF	DEC 12 2016	

Location Loc Qty Loc Code

ST346 103

m129390 103

M304R.250 *M304R 250* 304 SS Round bar .250		Purchased	No			100	f	11.3160	0.1	0.421053			
										**	FF	DEC 06 2016	

Location Loc Qty Loc Code

MAT028 11.316

m135249 11.316

M304TR0.500W.035 *M304TR0 500W 035* 304 RD Tube .500 x .035W		Purchased	No			110	f	139.8136	1.25	5.263158			
										**	FF	DEC 06 2016	

Location Loc Qty Loc Code

GA 50.8105275

m135373 50.8105275

GA002 58.5308864

m132872 1.6822064

m133611 3.994895

m134504 52.853785

MAT 30.4722075

m135498 30.4722075

3.2894735

1.9736841

NOT Pulled

Picklist Print

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Work Order ID: 151935

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

151935

D2332-041

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

M304TR1.000W.049

Purchased

No

100

f

38.6490

0.43

1.810526

M304TR1 000W 049

304 RD Tube 1.00 x .049W

**

FF

DEC 06 2016

Location

Loc Qty

Loc Code

GA002

38.649027

125250

31.360031

m130551

7.288996

1.810526

MS21042L4

Purchased

No

170

Each

2,548.000

1

4

MS21042L 4

Nut

**

FF

DEC 12 2016

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

260

m135058

260

OVER007

1500

m135774

500

m135864

1000

ST303

754

m135603

254

m135704

500

NAS1149D0416J

Purchased

No

170

Each

3,707.000

3

12

NAS1149D0416.J

WASHER

**

FF

DEC 12 2016

Location

Loc Qty

Loc Code

GA

29

m131511

29

ST260a

1976

m131511

1976

ST264

1702

m131511

1702

12

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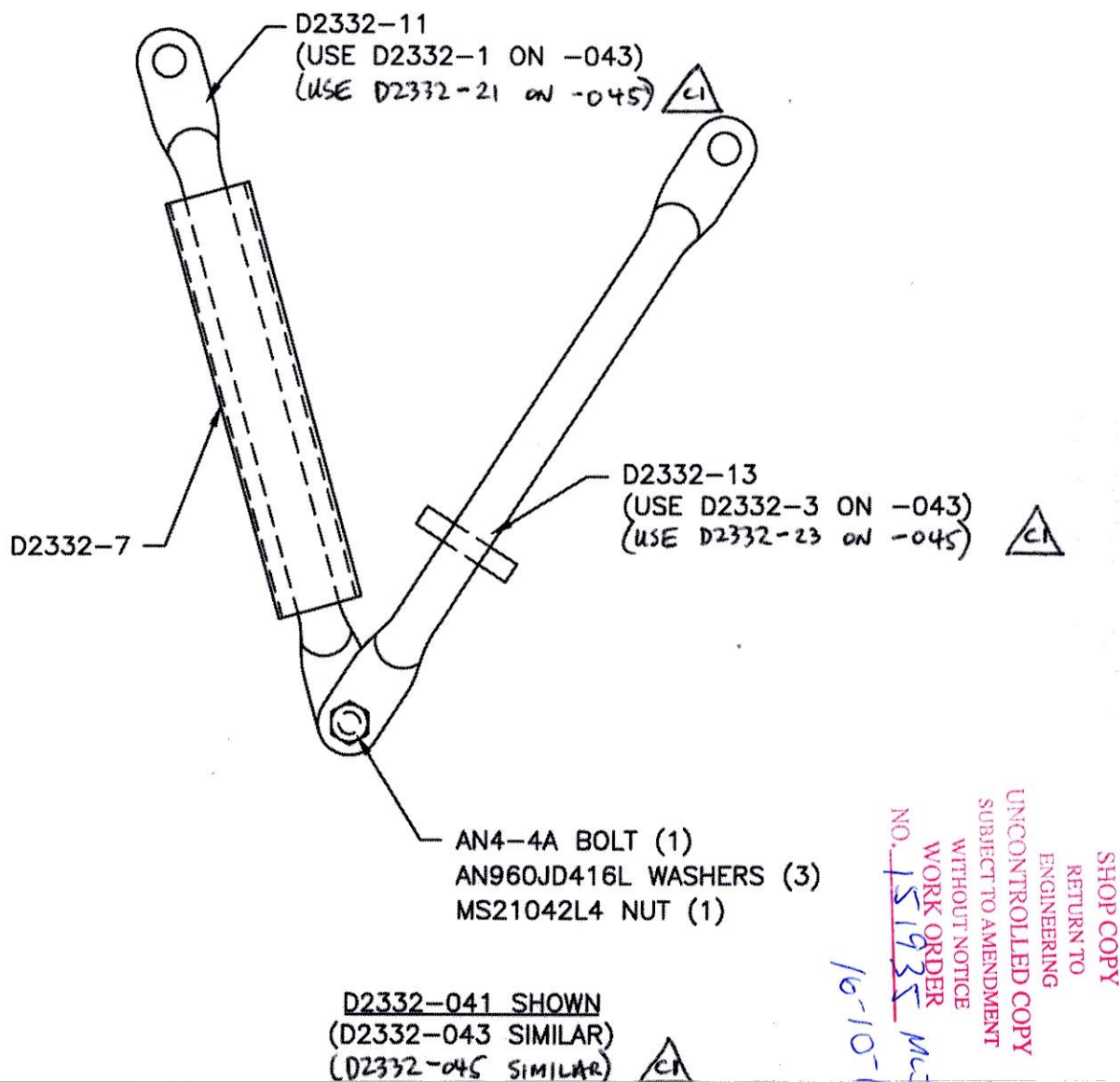
Shop Packet Print

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY		SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

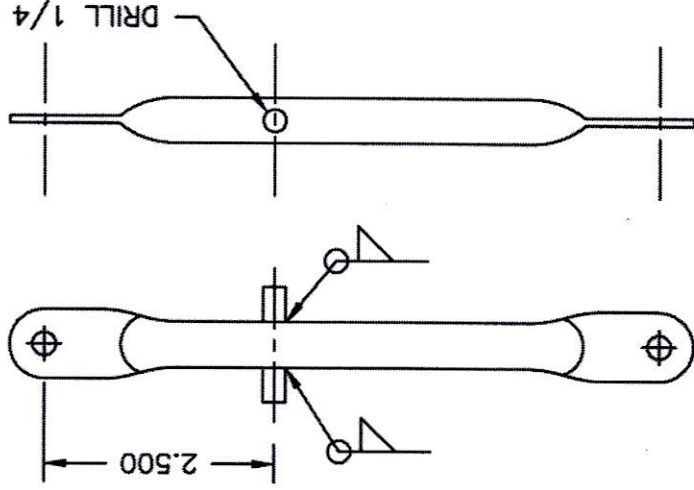
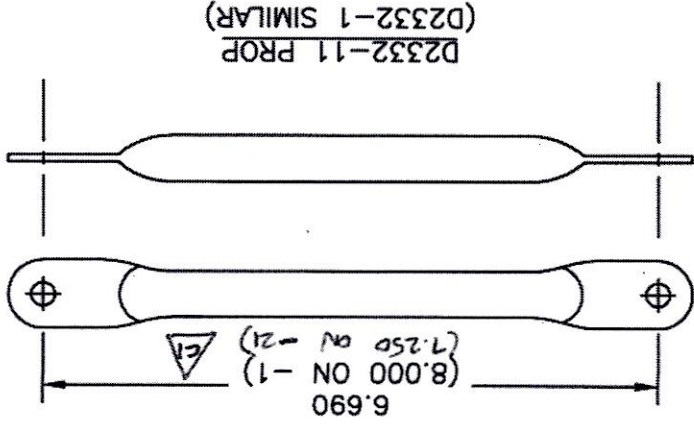
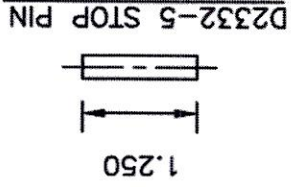
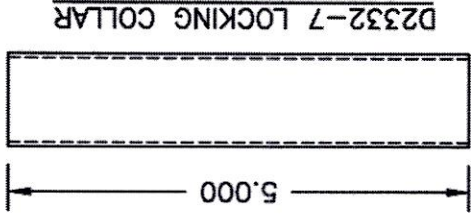


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DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	REV. C	
03.07.03	D2332	SHEET 2 OF 2	
TITLE		SCALE	
LID PROP ASSEMBLY		1:2	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD)	
		MAKE -043 PROP 8.00" LONG (OPT)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	



D2332-13
M/F D2332-11 & D2332-5
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

- NOTES:
1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
 2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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